

ABSTRACT

A rail manufacturing method is provided, in which a billet is hot-rolled into a rail form and the rail is cooled to ambient temperature. The foot part of the rail can
5 be mechanically restrained to improve the straightness of the rail during at least the period of cooling where the surface temperature is between 800 °C and 400 °C. In the subsequent cooling process, at least while the surface temperature of the foot of the rail is between 400 °C and 250 °C, the rail is kept in an upright state, and cooled naturally without using insulation or accelerated cooling.